

Date: Thursday, 8/23/2007 11:48:20 AM
 User: Kim Johnston

Process Sheet

36

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL PURGE CANISTER INSTALLATION
 Job Number : 34210
 Estimate Number : 10856
 P.O. Number :
 This Issue : 8/23/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D412706011
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : N/A
 Drawing Revision : N/A
 Previous Run : 33018 Material :
 Due Date : 9/3/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 07.08.23
 Comment : Est Rev: 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-706-011CHG001

07.08.29

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D20014 Valve 1/4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2001-4

Valve Assembly

32197

* Batch not in comp.

AS 08/04/24

4.0 D3262041 Fuel Purge Canister



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3262-041

Canister Assembly

37369

AS 08/04/24

5.0 D32641 Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3264-1

Bracket

B37370x1 B35133x1

AS 08/04/24

W/O:		WORK ORDER CHANGES					
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6.0

D329710098

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3297-1-0098 Hose Assembly

23286

AS 08/04/24 (X)

7.0

D329730085

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3297-3-0085 Hose Assembly

23289

AS 08/04/24 (X)

8.0

D329730210

HOSE ASS'Y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3297-3-0210 Hose Assembly

38448

AS 08/04/24 (X)

9.0

D3298001

Tube Assembly 25"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-001 Tube Assembly

38062

AS 08/04/24 (X)

10.0

D3298003

Tube Assembly 27"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-003 Tube Assembly

23294

AS 08/04/24 (X)

11.0

D3298005

Tube Assembly 23"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-005 Tube Assembly

38450

AS 08/04/24 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Description :

12.0

D3298007

Tube Assembly 8"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-007

Fitting

23296

AS 08/04/24

13.0

D3298009

Tube Assembly 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3298-009 Tube Assembly

38663

AS 08/04/24

14.0

D32991

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-1

Fitting

35138

AS 08/04/24

15.0

D32993

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3299-3

Fitting

35139

AS 08/04/24

16.0

D32995

Fitting



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D3299-5

Fitting

23303

AS 08/04/24

17.0

D33011

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-1

Doubler

35129 37077

AS 08/04/24

W/O:		WORK ORDER CHANGES					
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Description :

18.0

D33013

PLACARD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3301-3

Placard

23305

AS 08/04/24 (K)

19.0

D33021

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-1

Doubler

35129

AS 08/04/24 (K)

20.0

D33023

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3302-3

Doubler

38064

AS 08/04/24 (K)

21.0

D33291

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D3329-1

Bushing

34218

AS 08/04/24 (K)

22.0

AN35A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN3-5A

Bolt

M19356

AS 08/04/24 (K)

23.0

AN8146D

Plug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN814-6D

Plug

M17710

AS 08/04/24 (K)

Dart Aerospace Ltd

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Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN8156D

Union-M-Flare



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

3 AN815-6D

Plug

M17654

AS 08/04/24 (X)

25.0

AN8326D

UNION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN832-6D

Union

M17654

AS 08/04/24 (X)

26.0

AN8336D

Elbow, Bulkhead-M-Flare



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 AN833-6D

Union

M103978

AS 08/04/24 (X)

27.0

AN9246D

Nut



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

5 AN924-6D

Nut

104374

AS 08/04/24 (X)

28.0

AN9386D

Tee



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 AN938-6D

Tee

17654

AS 08/04/24 (X)

29.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

M107715

AS 08/04/24 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Part Number: D412706011

Job Number:



Seq. #:

Machine Or Operation:

Description :

8 AN960JD10

Washer

30.0

AN960JD10L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 AN960JD10L

Washer

M104885

AS 08/04/24 (X)

31.0

MS21042L3

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 MS21042L3

Nut (or -3)

M106883

AS 08/04/24 (X)

32.0

MS21919WDG9

Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21919WDG9

Clamp

M104715

AS 08/04/24 (X)

33.0

MS2192042

CLAMP(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 MS21920-42

Clamp

M107216

AS 08/04/24 (X)

34.0

MS287786

Packing



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

10 MS28778-6

O-Ring

M107591

AS 08/04/24 (X)

35.0

MS3548911

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

16323

AS 08/04/24 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

1 MS35489-11 Grommet

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/04/04 (X)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-706-011

Location:

PPP Rev:

lewB

AS 08/04/24 (X1)

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28

Job Completion



mf 08-04-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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